

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029100**Date Inspected:** 31-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** David Speakman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Elevator Safety Enclosures & Pier T1 Fender**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) Jamie Schlarb was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

The QAI witnessed work in progress related to Bid Item 85 (Pier T1 Tower Fender Ladder):

This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the Pier T1 Tower Fender Ladder (Ladders #101A and #102A). The ABF approved drawing numbers utilized were sheet numbers 101 and 102. The parts fit were mark #a to c (frame to frame), #c to #b (frame to frame) and #a to #d (rungs to frame). The ABM Welder was Ben Price (ID# 88) and utilizing ABM FCAW WPS #ABM-SAS-035 and #ABM-SAS-06.

The QAI observed ABM Certified Welding Inspector (CWI), David Speakman & Assistant Quality Control Inspector (QCI) Tony Corsaletti monitored the fit up and welding operations, checking pre-heat and interpass temperatures, perform dimensional and visual inspection. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions.

The QAI witnessed work in progress related to CCO 085 (Elevator Safety Enclosure Mesh Panels):

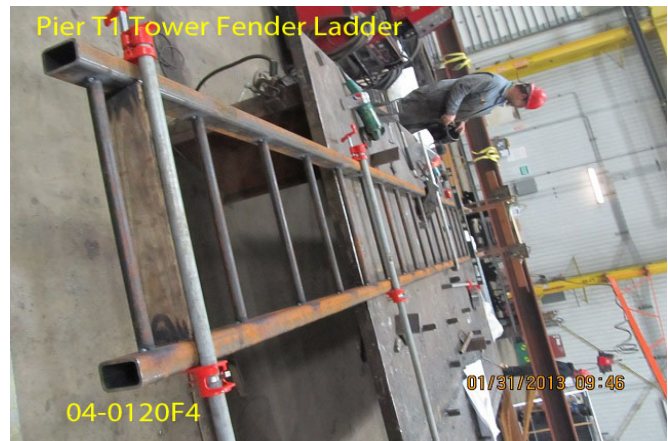
This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the Mesh Panels (Type 2B). The ABF approved drawing numbers utilized the existing drawings as well drawings that are

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part of the re-fabrication of the Mesh Panels included in RFI #ABF-RFI-003151R01. The parts fit were the U-Channel pieces, mesh screens cut down to size and holes drilled for bolt access. The ABM Welder was Mike Herbert(ID# H) and utilizing ABM FCAW WPS #ABM-SAS-034. The QAI observed ABM personnel checking proper fit up to the existing frames, verify bolt hole alignment and orientation of the mesh panel itself.

The QAI observed ABM Certified Welding Inspector (CWI), David Speakman & Assistant Quality Control Inspector (QCI) Tony Corsaletti monitored the fit up and welding operations, checking pre-heat and interpass temperatures, perform dimensional and visual inspection. The QAI observed that items witnessed appeared to be in conformance with the approved drawings (RFI) noted above, the standard specification and special provisions.



Summary of Conversations:

None unless noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Schlarb, Jamie

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer